

5/25


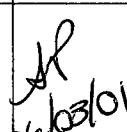

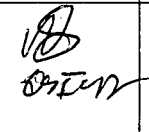

DART AEROSPACE LTD		Work Order:	23303
Description: Fitting		Part Number:	D3299-5
Dwg: D3299 Rev. <i>B</i> <i>04.11.16</i>		Qty:	10
Page 1 of 1			


Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	<i>PH</i>	05.05.25	10
2	MC	Cut blank: 2.950" long Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.625" Hex (M6061T6H1.625) Identify as D3299-5 Batch: <i>M17625</i>	<i>J.G</i>	05/11/11	11
3	MC	Turn as per Folio FA465 and Dwg D3299	<i>PH</i>	05/11/13	11
4	QC2	Inspect parts as they come off the CNC machine	<i>PH</i>	05/11/13	11
5	MV	Machine as per Folio FA465 and Dwg D3299	<i>MS</i>	05/12/06	11
6	QC2	Inspect parts as they come off the CNC machine	<i>MS</i>	05/12/06	11
7	QC8	Second check	<i>EP</i>	05/12/07	11
8	MV	Deburr	<i>MS</i>	05/12/07	11
9	PG	Issue P/O: <i>00000322</i> Anodize as per Dwg D3299 Possible Supplier: TNM Paint Material release note is required	<i>PH</i> <i>SP</i>	05/12/08 05/12/21	11 11
10	RG	Receive and Inspect for transit damage Ensure material release note is attached	<i>CL</i>	06/02/08	10
11	QC5	Inspect work to Step 10	<i>CL</i>	06/03/02	10
12	ST	Identify and Stock <i>Identify with a Part # & Batch # using a Permanent Fine Point Marker.</i>	<i>ST</i>	06/03/03	10
13	AC	Cost / part:	<i>U</i>	06/03/03	
14	DC	Close W/O Inspect Level 21	<i>PH</i>	06/03/06	10

Rev	Date	Change	Revised By	Approved
A	04.10.04	New issue	KJ/JLM	<i>[Signature]</i>

RELEASED
04.10.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-03-02	9	Supplier lost 1 part during Anodize process.		Purchasing to contact Supplier of missing part. Supplier looking for part	 06/03/02	 06-03-02	 06-03-02	 06-03-02

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/03/06

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	23303
Description: Fitting		Part Number:	D3299-5
Inspection Dwg: D3299	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.625	+/-0.010	1.626	✓			
1.250	+/-0.010	1.253	✓			
Ø1.00	+/-0.030	Ø1.002	✓			
Ø0.560	+0.005/-0.000	Ø0.561	✓			
Ø0.302	+0.005/-0.000	Ø0.307	✓			
0.083	+0.015/-0.000	.0845	✓			
30°	+/-0.5°	30°	✓			
53°	+/-0.5°	53°	✓			
1.00	+/-0.030	1.007	✓			
1.700	+/-0.010	1.698	✓			
R0.06	+/-0.030	R0.06	✓			
Ø0.476	+0.000/-0.005	Ø0.475	✓			
MOW for 9/16"-18	Min = 0.5653 Max = 0.573	0.571	✓			
0.20	+/-0.030	0.193	✓			
0.93	+/-0.030	0.924	✓			
0.150	+/-0.010	0.151	✓			
Ø0.688	+/-0.010	.688	✓			
Ø0.580	+0.005/-0.000	Ø.5845	✓			
0.50	+/-0.030	.50	✓			
2.85	+/-0.030	2.857	✓			

Measured by: <i>rmf</i>	Audited by: <i>EP / EP</i>	Prototype Approval:	N/A
Date: 05/11/13	Date: 05/11/13 05/12/13	Date:	N/A

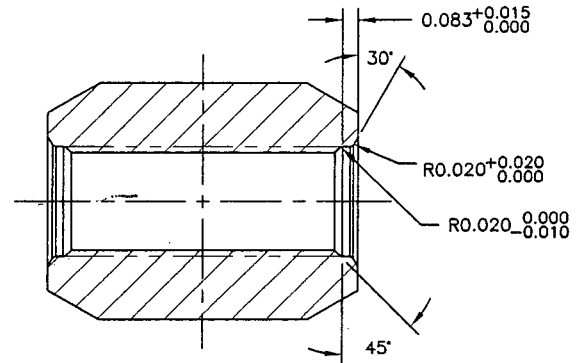
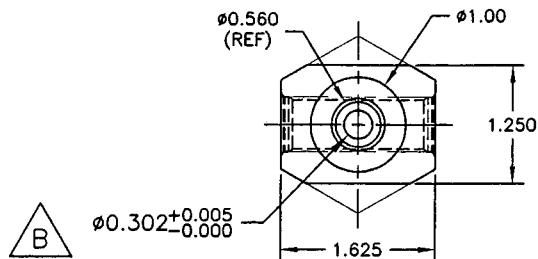
Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.313	KJ/JLM	<i>[Signature]</i>

RELEASED
05/15/25

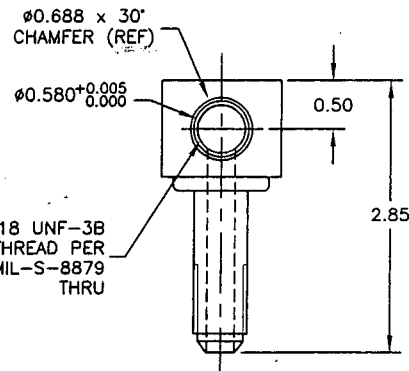
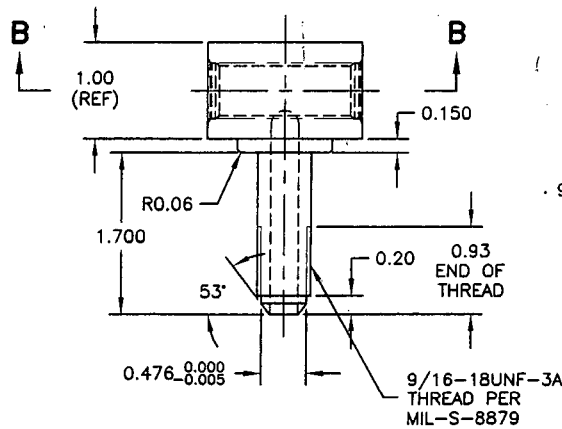


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

RELEASED
05.04.28



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
NOT TO BE USED FOR
REVISION NOTICE

WORK ORDER
NO. 23303

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 12, 2005
04:28 pm

Work Order No : 0023303
Project Name : D3299-5
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : D3299-5
Description : Fitting
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-12-05
Est Finish Date : 06-23-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

TNM



ANODISATION et PEINTURE TNM INC.

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2
Telephone: (514) 429-7777 Fax: (514) 429-5108
Certifié ISO 9001-2000 / AS9100 certified
approuvé NADCAP approved

C. OF C

45495

12-Jan-2006

CLIENT / CUSTOMER:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY , ONTARIO
K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE**

**PURCHASE ORDER/
NO. DE COMMANDE:** 00000322



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	11	11	D32995 FITTING B23303	BLUE ANODIZE PER MIL-A-8625F TYPE I CLASS 2 ALL OVER

Qty of 10

06-03-02

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: 
Directeur de la Qualité / Q.A. Manager

